

Date: Thursday, 11/06/2009 12:50:36 PM
 User: Julie Dawson

Process Sheet

| | |
|--|---|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : TUBE ASSEMBLY 25" |
| Job Number : 48507 | |
| Estimate Number : 11190 | |
| P.O. Number : | Part Number : D3298001 |
| This Issue : 11/06/2009 S.O. No. : | Drawing Number : D3298 REV A2 |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : / / Type : SMALL /MED FAB | Drawing Revision : A2 |
| Previous Run : 47421 | Material : |
| Written By : | Due Date : 19/06/2009 Qty: 10 Um: Each |
| Checked & Approved By : <u>JUD 09.06.11</u> | |
| Comment : Est A04.09.02 New issue KJ/JLM | |

Additional Product

Job Number:



| | | |
|----------------|------------------------------|----------------------|
| Seq. #: | Machine Or Operation: | Description : |
|----------------|------------------------------|----------------------|

| | | |
|-----|------------------|-----------------------------|
| 1.0 | M6061T6T0375W035 | 6061-T6 RD Tube .375 x.035W |
|-----|------------------|-----------------------------|



10X

Comment: Qty.: 2.1875 f(s)/Unit Total : 21.8747 f(s)

Cut tube to length as per Dwg D3298

Material: 6061-T6 (WW-T-700/6) tubing Ø0.375" x 0.035" wall (M6061T6T0.375W.035)

Identify as D3298-001

Batch: _____

M104913

M-L 09/06/16

| | | |
|-----|-----------|--------|
| 2.0 | MS208196D | Sleeve |
|-----|-----------|--------|



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Sleeve

Pick:

| | | | |
|-----|-------------|-------------|-------|
| Qty | Part Number | Description | Batch |
| 1 | MS20819-6D | Sleeve | _____ |

M110916

M-L 09/06/16

| | | |
|-----|---------|-----|
| 3.0 | AN8186D | Nut |
|-----|---------|-----|



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Coupling Nut

Pick:

| | | | |
|-----|-------------|-------------|-------|
| Qty | Part Number | Description | Batch |
| 1 | AN818-6D | Nut | _____ |

M108940

M-L 09/06/16

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Thursday, 11/06/2009 12:50:36 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE ASSEMBLY 25"

Job Number: 48507

Part Number: D3298001

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



10X

Comment: SMALL & MEDIUM FAB RESOURCE 1

Bend tube as per template D3298-001T1 & Dwg D3298

Flare end as per Dwg D3298.

Ensure that sleeves and coupling are installed first

M.L. 09/06/16

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

50960617 (X10)

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: 51195

SS 09/06/17 (X10)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/18 (X10)

Job Completion



mf
09-06-17

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries



| | | | |
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| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3298 | REV. A SHEET 1 OF 7 |
| DATE 04.07.06 | | TITLE TUBE ASSEMBLIES | SCALE NTS |
| A | 04.07.06 | NEW ISSUE | |
| A1 | <i>[Signature]</i> 04.11.30 | CORRECT VIEW D3298-003; 16.50 WAS 15.75 | |
| A2 | <i>[Signature]</i> 05.05.06 | FOR D3298-001/-003 16.00 WAS 16.50 | |

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| P/N | TEMPLATE | CUT LENGTH OF TUBE | MS20819-6D SLEEVE | AN818-6D NUT | DESC. | MATERIAL |
|-----------|-------------|-----------------------|-------------------|--------------|------------|---|
| D3298-001 | D3298-001T1 | 25.00 | 2 | 2 | TUBE ASS'Y | 6061-T6 0.375 OD x 0.035 W (WW-T-700/6) |
| D3298-003 | D3298-003T1 | 27.00 | 2 | 2 | TUBE ASS'Y | 6061-T6 0.375 OD x 0.035 W (WW-T-700/6) |
| D3298-005 | D3298-005T1 | 23.00 | 2 | 2 | TUBE ASS'Y | 6061-T6 0.375 OD x 0.035 W (WW-T-700/6) |
| D3298-007 | D3298-007T1 | 8.00 | 2 | 2 | TUBE ASS'Y | 6061-T6 0.375 OD x 0.035 W (WW-T-700/6) |
| D3298-009 | D3298-009T1 | 6.00 | 1 | 1 | TUBE ASS'Y | 6061-T6 0.375 OD x 0.035 W (WW-T-700/6) |
| D3298-011 | D3298-011T1 | 8.00 | 2 | 2 | TUBE ASS'Y | 6061-T6 0.375 OD x 0.035 W (WW-T-700/6) |
| D3298-013 | D3298-013T1 | 10.00 | 2 | 2 | TUBE ASS'Y | 6061-T6 0.375 OD x 0.035 W (WW-T-700/6) |
| D3298-015 | D3298-015T1 | 14.00 | 1 | 1 | TUBE ASS'Y | 6061-T6 0.375 OD x 0.035 W (WW-T-700/6) |

Notes:

- (1) TUBING ASSEMBLIES TO BE CUT AND BENT IN ACCORDANCE WITH TEMPLATES.
- (2) TUBES TO BE FLARED 37° TO MATE WITH FITTINGS MADE TO MS33514.
- (3) ENSURE SEAMLESS TUBING IS USED.
- (4) 5052 (WW-T-700/4) TUBING MAY BE SUBSTITUTED WHEN 6061 TUBING IS NOT AVAILABLE.
- (5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- (6) ALL DIMENSIONS ARE IN INCHES
- (7) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

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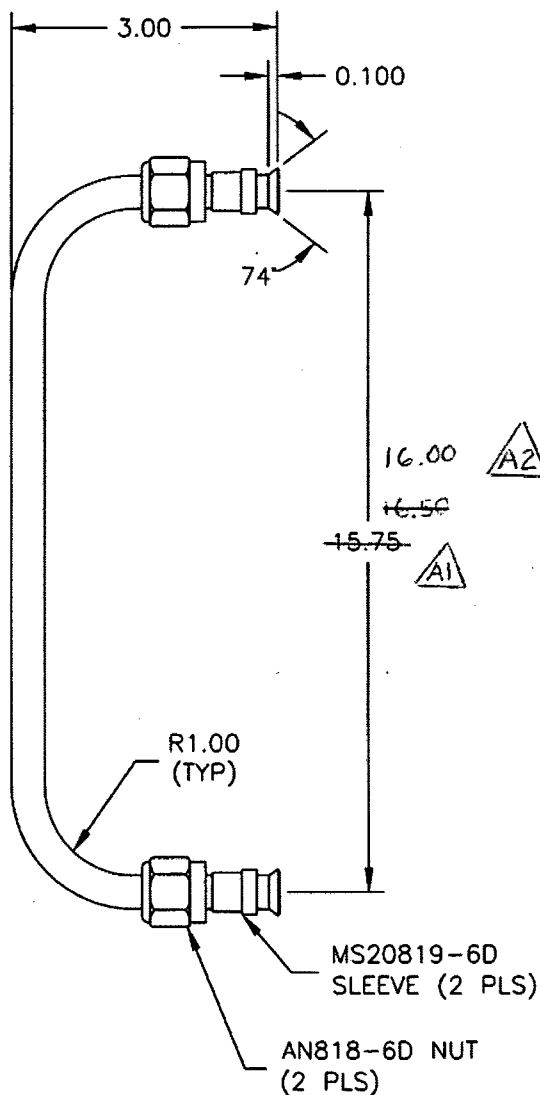
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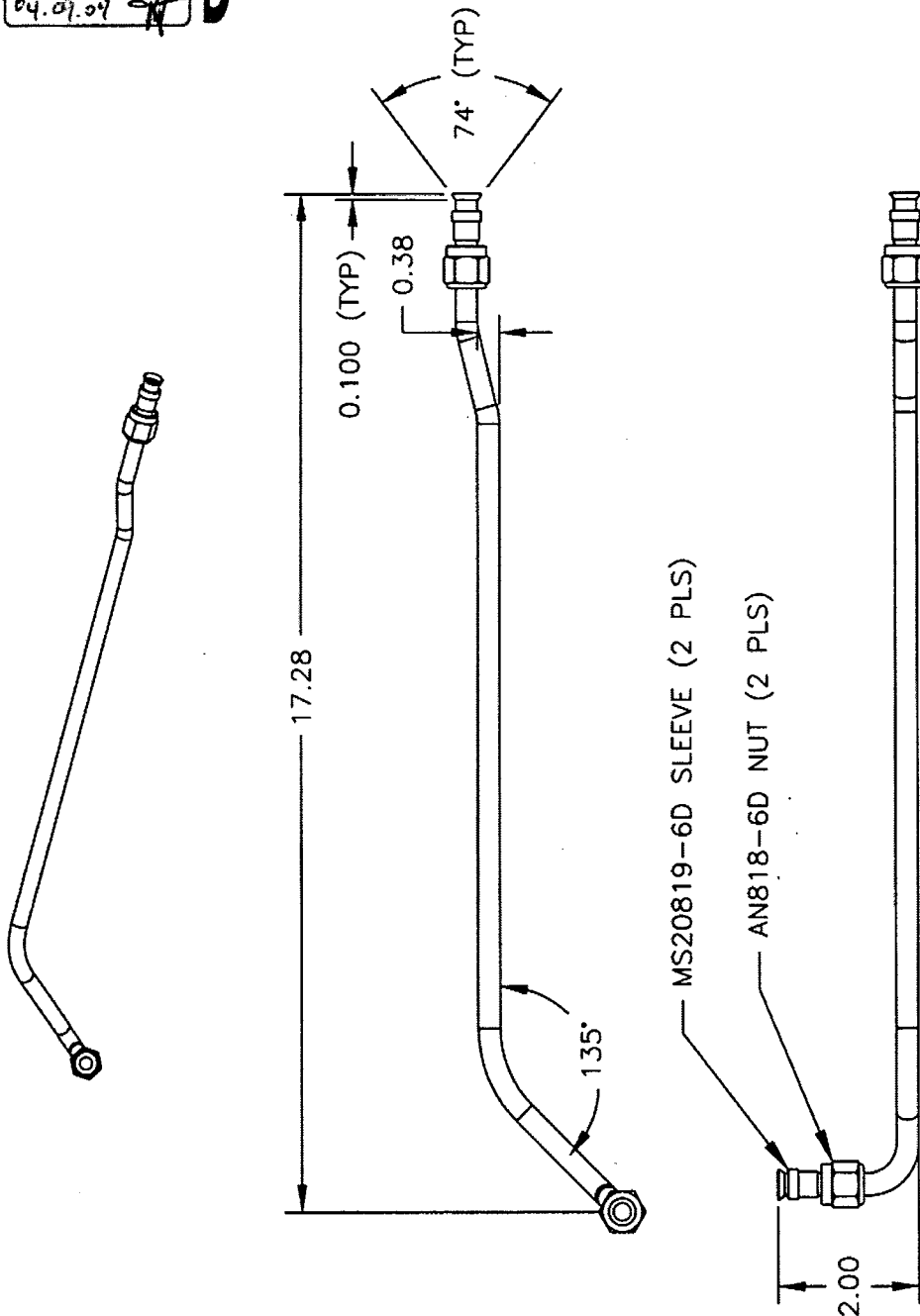
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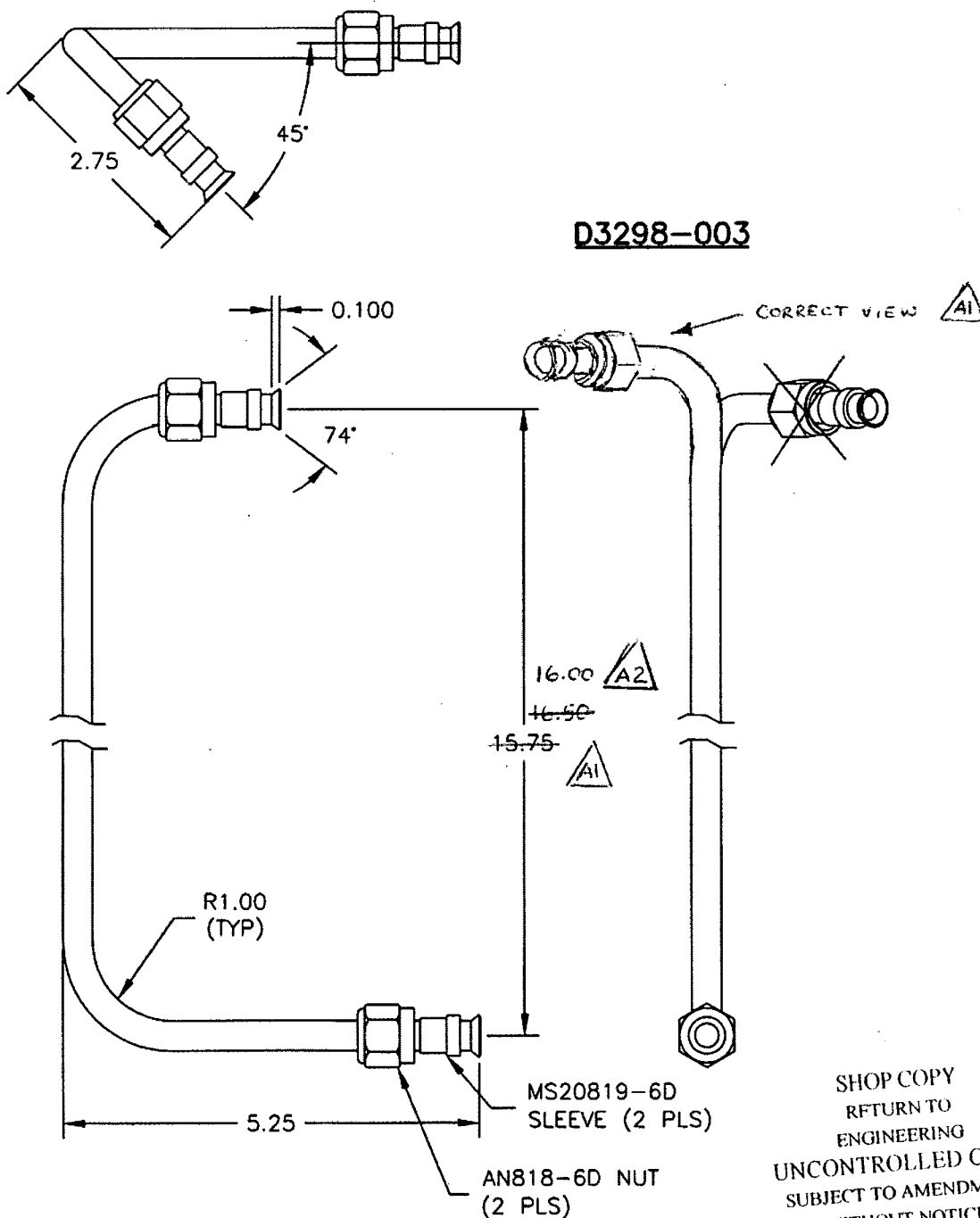
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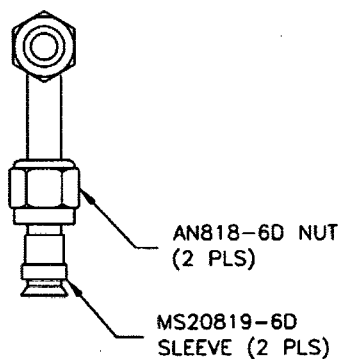
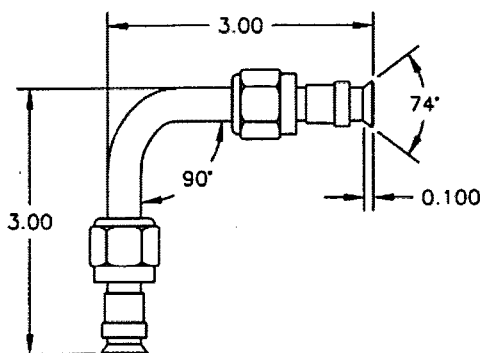
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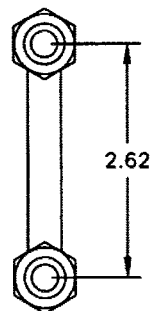
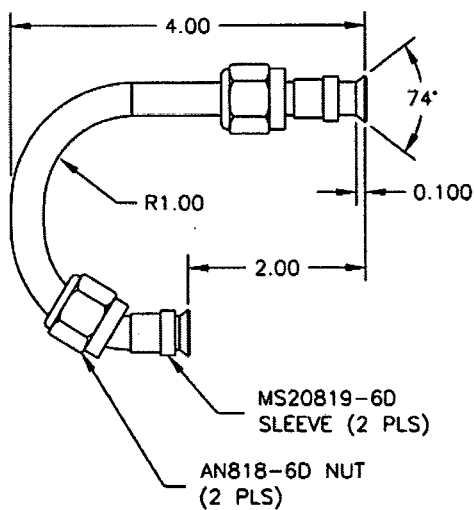


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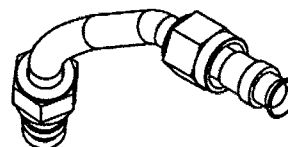
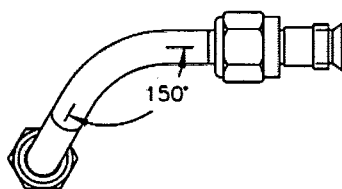
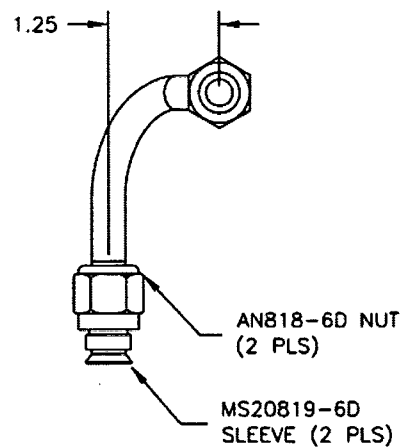
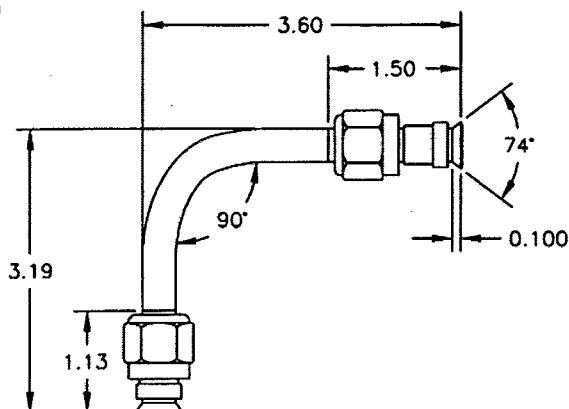
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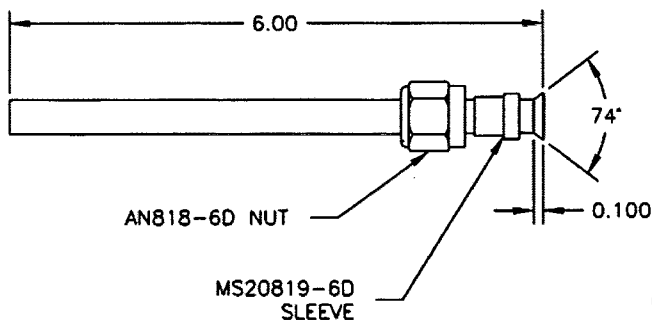


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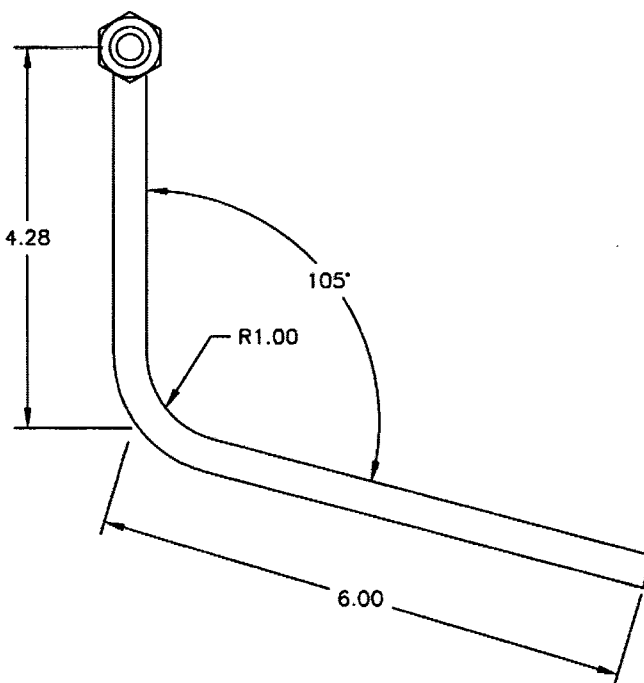
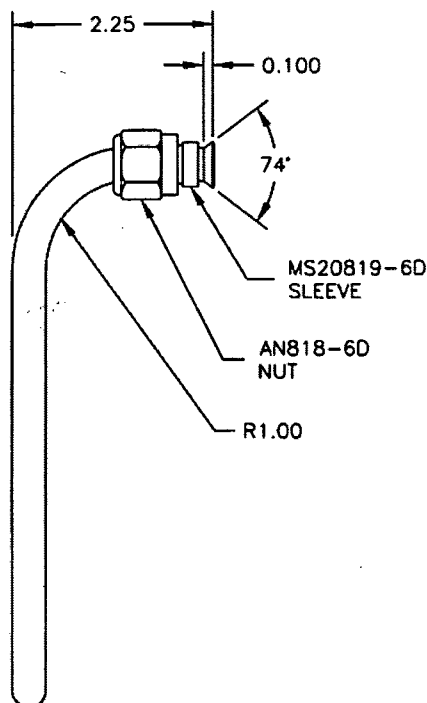
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